

Work Order ID 60301

Thursday, July 01, 2010 1:09:11 PM



Page 1

Item ID: D2602-2

Revision ID:

Accept



Item Name: Console Side, 206 Console

Start Date: 7/1/2010 Start Qty: 6.00

Required Date: 7/8/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:
Customer:

Setup

Start



Stop



Run

Start



Stop



Approvals:

Process Plan:

Date: 10-7-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2602

Rev B

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2602 ☐ *****Same Cutting File for -1 & -2 ***** ☐ Dwg
Rev: B ☐ Prog Rev: B ☐ 2-Deburr if necessary

2024 . 046

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

810108103

B 10-8-3

(6)

B 10-8-3

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 7/8/2010 Req'd Qty: 6.00

Reference:



Cust Item ID:
Customer:

Setup Start



Stop



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

1-Deburr if necessary 2-Form as per Dwg D2602

So 10/08/04

(6)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solo 10/08/04

(46)

(-2)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

M 10/08/05

X6

W/O:		WORK ORDER CHANGES					
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Item Name: Console Side, 206 Console

Start Date: 7/1/2010 Start Qty: 6.00

Required Date: 7/8/2010 Req'd Qty: 6.00

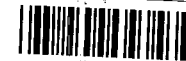
Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

6 BR 10-8-4

170



Packaging

Packaging

Identify as per dwg & Stock Location: 178

Memo

0.00

0.00

10/8/6 SP (C)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/08/09 MF 10-8-06

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, July 01, 2010 1:09:15 PM

Page 1

Work Order ID: 60301

Parent Item: D2602-2

Parent Item Name: Console Side, 206 Console

Start Date: 7/1/2010

Start Qty: 6.00

Required Date: 7/8/2010

Required Qty: 6.00

Comments:

IPP E 04.02.25 Reformat KJ/RF

Note: Issue with part number D2602-1

IPP Rev:E Now On Waterjet 07-03-22 JLM

IPP Rev:F RevB as per dwg ECN1059 DD vereified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	407.4400	1.3472	8.508632			
2024-T3 .040 sheet													

Location

MAT

114415

MAT22

110305

111786

112291

112331

113162

Loc Qty

96

96

311.44

80.33

13.76

28.25

52

137.1

Loc Code

113005

1310-8.3

6

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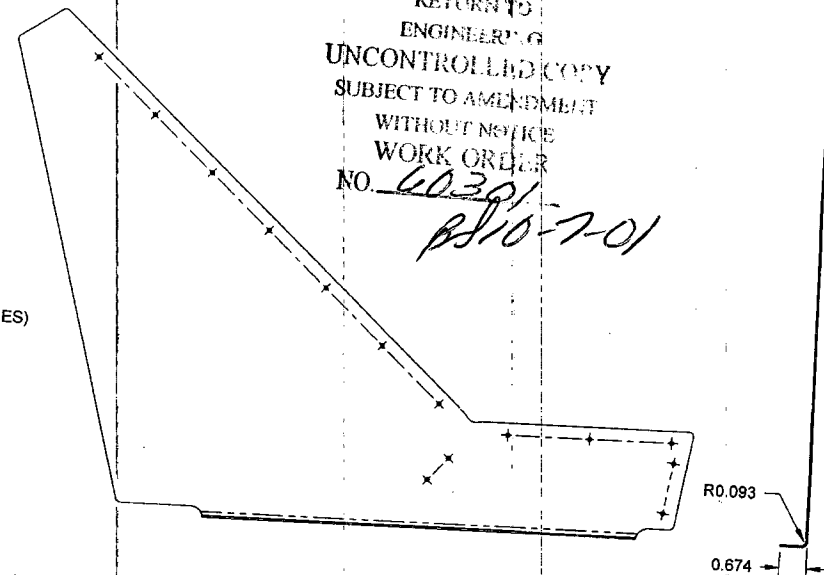
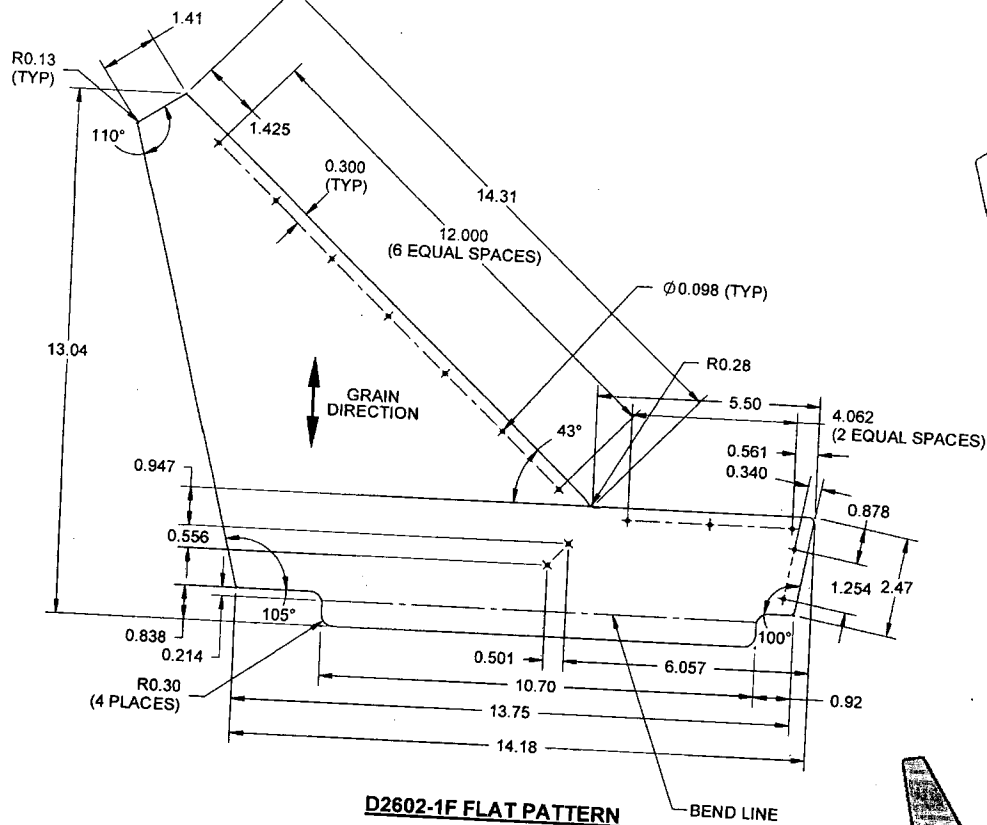
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**D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)
(D2602-2 OPPOSITE)**

RELEASED
67-12-12

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.38 lbs

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES		DC	07.11.07
A	D2602 WAS D206-547-21/22		BW	07.10.22
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	3C			
CHECKED	1E			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	07.11.07	DRAWING NO. D2602	REV.	
		TITLE	SHEET 1 OF 1	
		CONSOLE SIDE	SCALE	
		COPYRIGHT © 1987 BY DART AEROSPACE LTD		1:
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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